











Date: Tuesday, 9/11/2007 7:47:41 AM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARING ASSEMBLY
Job Number	: 34532		
Estimate Number	: 10716		
P.O. Number	: N/A	Part Number	: D3121241
This Issue	: 9/11/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3121 REV D
First Issue	: N/A	Project Number	: N/A
Previous Run	: 34523	Drawing Revision	: D
	Type : MACHINED PARTS	Material	: N/A
Written By	:	Due Date	: 9/13/2007
Checked & Approved By	:	Qty:	13
Comment	: Est Rev:A 04.02.18 New issue KJ/DS	Um:	20 Each

Seq. #:	Machine Or Operation:	Description :
1.0	MDELNR12500	DELIN ROUND BAR 1.25"
  <p>Comment: Qty.: 0.0546 f(s)/Unit Total: 1.0920 f(s) Material: Ø1.25 Delrin Rod (M-DELIN-R1.2500) Identify as D3121-25 Batch: N/A</p>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
  <p>Comment: HARDINGE CNC LATHE SMALL 1-Turn D3121-25 Cap as per Folio FA387 2-Deburr N/A</p>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
  <p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE N/A</p>		
4.0	QC8	SECOND CHECK
  <p>Comment: SECOND CHECK N/A</p>		
5.0	D312123	Bearing
  <p>Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3121-23 Bearing B32170 X13</p>		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/09/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121 B 32259

J.L 05/09/11

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

30 01.09.11

(13)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

02/09/11 (13)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

13
02/09/11

Job Completion



u 05/09/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

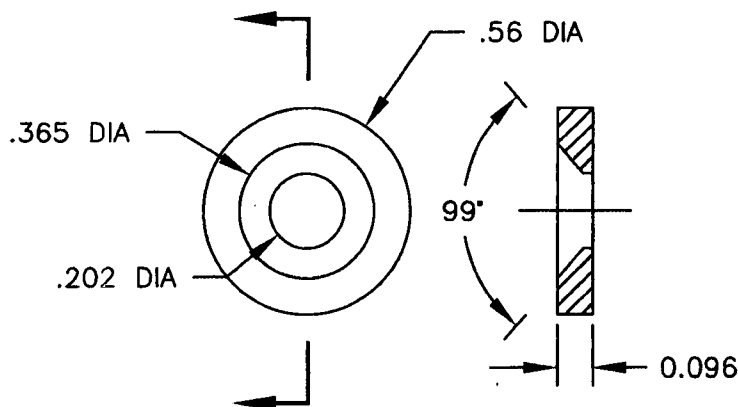
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

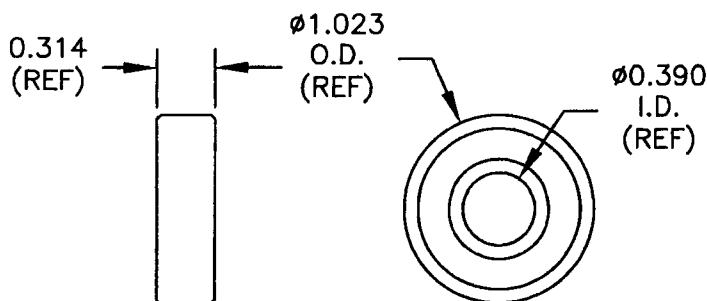
NOTE: Date & initial all entries

DART

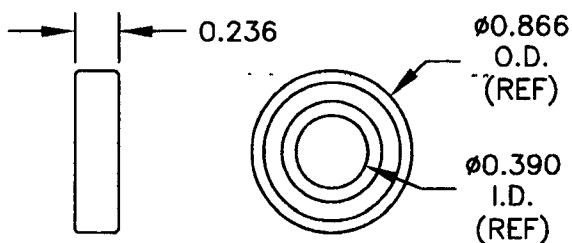
DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. D SHEET 10 OF 10
DATE 06.05.17	TITLE BRACKET ASSEMBLY		SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

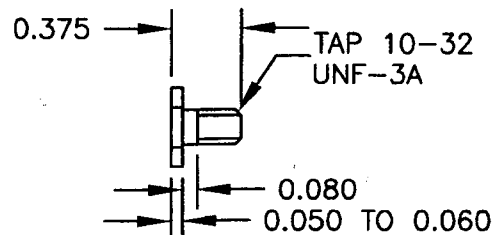
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

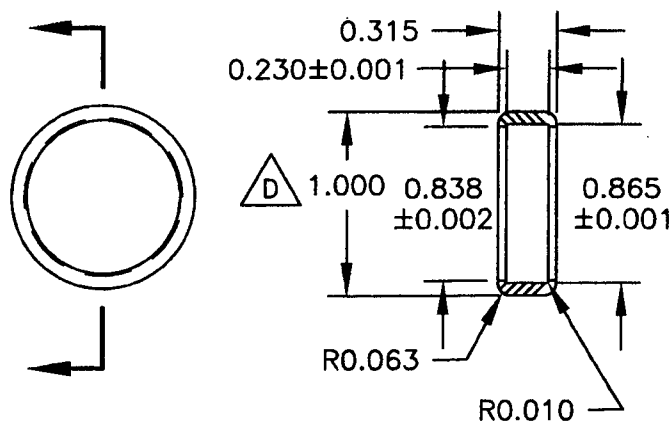
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES

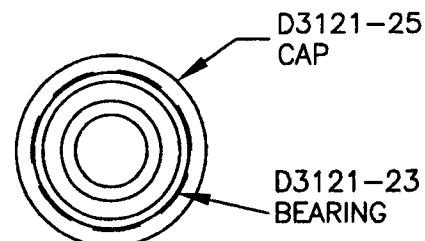
**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

RELEASED
06 06 02

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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